

# Work Order ID 70897

Thursday, June 16, 2011 2:41:42 PM



ASAP

Page 1

Item ID: D3262-5

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 6/16/2011 Start Qty: 400

Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 400

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 6-16-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3262

E

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 6.000" x 0.500" x 5.400" long Bar

OK 11/06/24

6 15

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per dwg D3262  
Machine as per Folio FA902 and Dwg D3262  
FOLIO REV: AE  
DWG REV: E  
TAP USING JIG DT9636  
Deburr

OK 11/06/24

6 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries





**Work Order ID 70897**

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Item ID:	D3262-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Cap					
Start Date:	6/16/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	6/20/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		11/06/24		6	8		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		11.2.27		4	6		
140  Packaging Packaging	Identify as per dwg & Stock Location:   Memo	0.00 0.00		1106.27					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**Work Order ID 70897**

Thursday, June 16, 2011 2:41:43 PM

Page 3

Item ID: D3262-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 6/16/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/27 JG  
ME  
11-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 16, 2011 2:41:34 PM

Page 1

Work Order ID: 70897



Parent Item: D3262-5



Parent Item Name: Cap

Start Date: 6/16/2011

Required Date: 6/20/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP  
Rev:B as per ECN10-571 DD 10.05.10 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	42.0000	0.96	4.042105			



6061-T6 Bar .500 x 6.00

Location

Loc Qty

Loc Code

MAT004

42

→ 112567

22

115045

20

4.05 *amr 6/16/24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

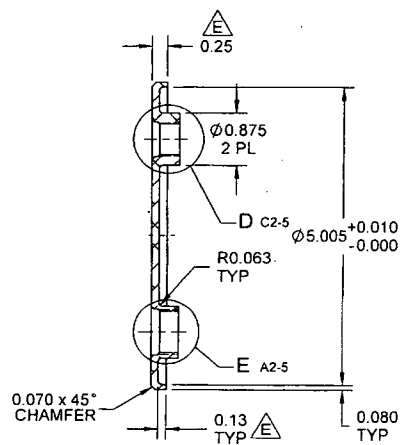
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

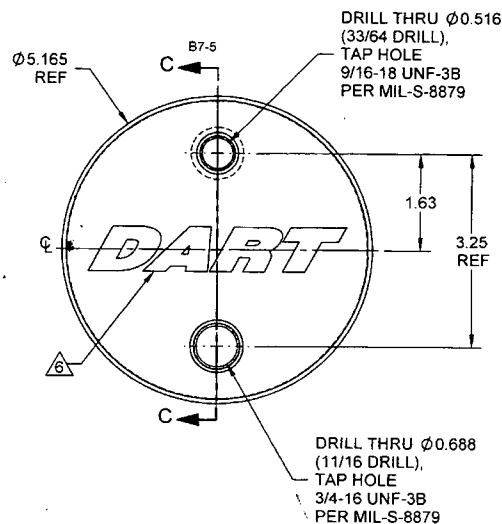
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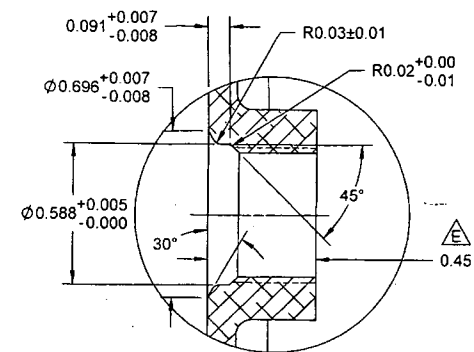




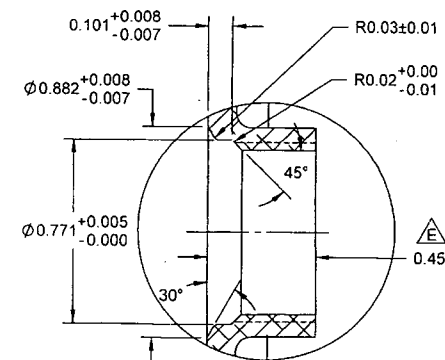
**SECTION C-C** D5-5



**D3262-5 CAP**



**DETAIL D** C7-5  
SCALE 2X



**DETAIL E** B7-5  
SCALE 2X

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3262	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FUEL PURGE CANISTER	NTS
DATE	10.05.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
2010-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 70897
<b>Description:</b> Cap		<b>Part Number:</b> D3262-5
<b>Inspection Dwg:</b> D3262	<b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	+/-0.030	.440	—		Vern	ML-7
0.25	+/-0.030	.250	—		"	"
Ø0.875	+/-0.010	Ø.875	—		"	"
Ø5.005	+0.010/-0.000	Ø5.005	—		"	"
R0.063	+/-0.010	R.063	—		R-G	
0.080	+/-0.010	.078	—		Vern	ML-7
0.13	+/-0.030	.129	—		"	"
0.070 x 45°	+/-0.010 x 0.5°	.073 x 45°	—		"	"
Ø5.165 Ref	+/-0.010	Ø5.166	—		"	"
1.63	+/-0.030	1.624	—		"	"
3.25 Ref	+/-0.030	3.248	—		"	"
9/16-18 UNF-3B	N/A	9/16-18 UNF	—		"	"
3/4-16 UNF-3B	N/A	3/4-16 UNF	—		"	"
0.091	+0.007/-0.008	.090	—		Vern	ML-7
R0.03	+/-0.010	R.030	—		R-G	
R0.02	+0.00/-0.01	R.020	—		"	
45°	+/-0.5°	45°	—		com square	
30°	+/-0.5°	30°	—		"	
Ø0.588	+0.005/-0.000	Ø.588	—		Vern	ML-7
Ø0.696	+0.007/-0.008	Ø.695	—		"	"
0.101	+0.008/-0.007	.101	—		"	"
R0.03	+/-0.010	R.030	—		R-G	
R0.02	+0.00/-0.01	R.020	—		"	
45°	+/-0.5°	45°	—		com square	
30°	+/-0.5°	30°	—		"	
Ø0.771	+0.005/-0.000	Ø.772	—		Vern	ML-7
Ø0.882	+0.008/-0.007	Ø.882	—		"	"

<b>Measured by:</b> <i>AM</i>	<b>Audited by:</b> <i>RE</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 11/06/24	<b>Date:</b> 11.6.27	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries